

Date: Tuesday, 3/11/2008 9:58:17 AM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	CROSSBOLT SPACER
Job Number	37767		Part Number	D2743
Estimate Number	10329		Drawing Number	D2743 REV B
P.O. Number	:		Project Number	N/A
This Issue	3/11/2008	S.O. No. :	Drawing Revision	B
Prsht Rev.	NC		Material	:
First Issue	11	Type : MACHINED PARTS	Due Date	4/15/2008
Previous Run	36030		Qty:	200
Written By	11/08 03 11		Um:	Each
Checked & Approved By				
Comment	Est E 05.04.13 Reformat; removed tumble and deburr step K J/JLM			

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6T0625W065	6061-T6 Tube .625 x .065W 
		Comment: Qty.: 0.2800 f(s)/Unit Total : 56.0070 f(s) Material: 6061-T6 (WW-T-700/6) Ø0.625" x 0.065" wall (M6061T6T0.625W.065) Batch: 24 de M104627 24 de M106197 MMF 08/04/09 204
2.0	HARDINGE	HARDINGE CNC LATHE SMALL 
		Comment: 1-TURN AS PER FOLIO FA202 & DWG D2743 FOLIO REV: <u>A</u> DWG REV: <u>B</u>
		2-DEBURR AS REQUIRED 
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE 
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE 
4.0	QC8	SECOND CHECK 
		Comment: SECOND CHECK 
5.0	PACKAGING 1	PACKAGING RESOURCE #1 
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>Dartley</u> 8/4/09 SP 2001X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 3/11/2008 9:58:18 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CROSSBOLT SPACER

Job Number: 37767

Part Number: D2743

Job Number:



Seq. #: Machine Or Operation:

Description:

6.0 QC21

FINAL INSPECTION/W/O RELEASE



08/04/10 J

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-04-09

W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	37767
Description: Cross Bolt Spacer	Part Number:	D2743
Inspection Dwg: D2743      Rev: B		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

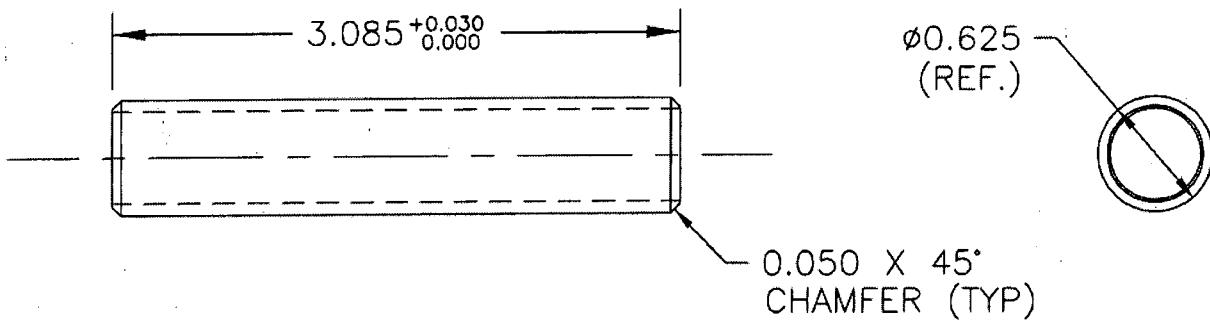
Measured by:	MMF /gml	Audited by:	DJP	Prototype Approval:	N/A
Date:	08/04/08	Date:	08/04/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue	KJ/RF	
B	06.11.20	Tolerance $+-0.010 \times 45^\circ$ was $0.48 \times 45^\circ$	KJ/JLM	



DESIGN	DRAWN BY	DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED	APPROVED	DRAWING NO. REV. B D2743 SHEET 1 OF 1
DATE		TITLE SCALE 98.12.08 CROSS BOLT SPACER 1:1
A	98.04.16	NEW ISSUE
B	98.12.08	3.085 WAS 3.060

RELEASED  
98.12.16 DS



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 37767

MATERIAL: 6061-T6 (WW-T-700/6) 0.625 DIA. X 0.065 WALL  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED